

Work Order ID 148022

148022

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June 20, 2016 10:18:16 AM

Item ID: D206-642-447 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 1.00 *1* Customer:

Reference: DISASSEMBLE

Approvals: Process Plan: SA Date: 6/24/16 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D206-642	O								

170

0.00

170

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK D206-642-447 X 1 B101002

DISASSEMBLE AND RETURN TO STOCK UNDER ORIGINAL BATCH NUMBERS:

Gary D3537-1 X 6 102254

FP001 D3537-3 X 1 101021

FP001 MS27039C1-08 X 60 124586

St264 NAS1149D0332J X 60 125807

FP001 D3536-37 X 1 86250

FP002 D3535-37 X 1 84827

FP001 D3536-23 X 1 98259

FP002 D3535-23 X 1 98284

FP001 D3536-15 X 1 98931

FP002 D3535-15 X 1 93045

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148022

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Item ID: D206-642-447

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 1.00

1

Customer:

Reference: DISASSEMBLE

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ML3

JUN 21 2016

Su 6/20/16
⊕

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 148022

148022

Parent Item: D206-642-447

D206-642-447

Parent Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016

Required Date: 6/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-642-447

Manufactured No

Each 0.0000

1

D206-642-447

Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

101002x1

**

SH 6/20/16

D3535-15

Manufactured No

Each 19.0000

-1

D3535-15

Wearplate Fwd

**

Location

Loc Qty

Loc Code

FP002

18

101646

1

110746

1

113123

3

113702

13

Return2016

1

101646

1

D3535-23

Manufactured No

Each 20.0000

-1

D3535-23

Wearplate Center Fwd

**

Location

Loc Qty

Loc Code

FG

2

93181

2

FP002

17

114930

17

Return2016

1

106662

1

xl 93045

SH 06/20/16

xl 98284

SH 6/20/16

Picklist Print

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Work Order ID: 148022

148022

Parent Item: D206-642-447

D206-642-447

Parent Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016

Required Date: 6/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3535-37

Manufactured No

Each 7.0000

-1

D3535-37

Wearplate Aft

1 x 84821 SH
6/20/16

Location

Loc Qty

Loc Code

FP002

7

106044

3

111879

4

D3536-15

Manufactured No

Each 12.0000

-1

D3536-15

Gasket Fwd

Location

Loc Qty

Loc Code

FG

4

85604

2

93893

2

FP001

7

113613

7

Return2016

1

106020

1

D3536-23

Manufactured No

Each 18.0000

-1

D3536-23

Gasket Center Fwd

Location

Loc Qty

Loc Code

FG

2

85295

2

FP001

15

114897

3

115557

12

Return2016

1

107548

1

98259 x 1 SH 6/20/16

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Work Order ID: 148022

148022

Parent Item: D206-642-447

D206-642-447

Parent Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016

Required Date: 6/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3536-37 Manufactured No

Each 12.0000

-1

D3536-37

86250 X 1 SH 6/20/16

Gasket Aft

Location

Loc Qty

Loc Code

FP001

12

111877

12

D3537-1 Manufactured No

Each 36.0000

-6

D3537-1

Wearpad

Location

Loc Qty

Loc Code

FG

14

79833

4

88562

10

FP001

12

141922

7

142912

5

Return2016

9

107384

9

ST184

1

125911

1

X6 102254
SH 6/20/16

Give to Gary
for a an
installation
ASAP

Picklist Print

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Work Order ID: 148022

148022

Parent Item: D206-642-447

D206-642-447

Parent Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016

Required Date: 6/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

Each

54.0000

-1

D3537-3

Wearpad

Location

Loc Qty

Loc Code

FG
86237
FP001
141220
141921
Return2016
104350
120646
ST184
120646

8
8
43
12
31
2
1
1
1
1

101 021 X 1 SA 6/20/16

MS27039C1-08

Purchased No

Each

610.0000

-60

MS27039C1-08

SCREW

Location

Loc Qty

Loc Code

FP001
m132317
m134166
m134370
OVER007
m134955

360
115
190
55
250
250

60x 124 586
SA 06/20/16

Picklist Print

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Work Order ID: 148022

148022

Parent Item: D206-642-447

D206-642-447

Parent Item Name: Standard Wearplates, Low & High Gear 206L / L1 / L3 / L4 / 407 Fits LH or RH

Start Date: 6/20/2016

Required Date: 6/20/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

Each

1,095.000

-60

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

CA	6
m129682	6
FP001	16
m134502	16
ST260a	564
m134848	564
ST264	509
m134502	24
m134738	485

125807X6

SH 6/20/14.

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Shop Packet Print

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Work Order ID 101002

April-30-13 2:38:04 PM

101002

Copy of original

Page 1

Item ID: D206-642-447 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 4/25/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/10/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 13-05-02 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D206-642	0

100, *js* 0.00
 100
 DC Memo 0.00 *DAS 16 13/07/15*
 Document Control Photocopy bluefile and create labels per PPP D206-642-447 CHG002

for CL 13-7-4

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

13-07-03 js
SP

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.00 *DAS 16 13/07/15*
 Quality Control

(X)

Work Order ID 101002

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101002

Page 2

Item ID: D206-642-447

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 4/25/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-447

FG061**13-7-05**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/7/8**MF 13-7-8**

Picklist Print

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Page 1

Work Order ID: 101002

Parent Item: D206-642-447

Parent Item Name: Wearshoe

Start Date: 4/25/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3537-1 Wearpad		Manufactured	No			110	Each	126.0000		6 102254 ✓ 20 SP.			
--------------------	--	--------------	----	--	--	-----	------	----------	--	-------------------	--	--	--

Location	Loc Qty	Loc Code
FG	20	
79833	10	
88562	10	
FP001	106	
83254	1	
83255	3	
87697	1	
88562	9	
91668	24	
94395	1	
97289	1	
98494	54	
98495	12	

D3537-3 Wearpad		Manufactured	No			110	Each	15.0000		101021 ✓ 20 13-07-03 SP.		
--------------------	--	--------------	----	--	--	-----	------	---------	--	--------------------------	--	--

Location	Loc Qty	Loc Code
FG	8	
86237	8	
FP001	7	
78836	1	
98447	6	

Picklist Print

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Page 2

Work Order ID: 101002
Parent Item: D206-642-447
Parent Item Name: Wearshoe

Start Date: 4/25/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

MS27039G1-08
SCREW

Purchased No

110 Each 1,520.0000

60

60

yo SP

Location	Loc Qty	Loc Code
FP001	4	
122141	4	
ST308	44	
123352	44	
ST508	1472	
124586	1472	

NAS1149D0332J
Washer

Purchased No

110 Each 1,492.0000

60

60

124586
125807 yo SP

Location	Loc Qty	Loc Code
ST293	915	
125268	915	
ST294	577	
122973	68	
125044	509	

D3535-15
Wearshoe

Manufactured No

110 Each 22.0000

0

1

yo SP

Location	Loc Qty	Loc Code
FP002	22	
93045	9	
98382	13	

D3536-15
Gasket

Manufactured No

110 Each 28.0000

0

1

yo 13-07-03
SP

Location	Loc Qty	Loc Code
FG	4	
85604	2	
93893	2	
FP001	24	
73318	1	
81343	1	
97052	12	
98931	10	

98931

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 101002

Parent Item: D206-642-447

Parent Item Name: Wearshoe

Start Date: 4/25/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

D3535-23

Wearshoe

Manufactured No

110 Each 20.0000

99284 79 SP

Location

Loc Qty

Loc Code

FG

2

93181

2

FP002

18

96125

5

97033

13

D3536-23

Gasket

Manufactured No

110 Each 40.0000

1 79 SP

Location

Loc Qty

Loc Code

FG

2

85295

2

FP001

38

74510

1

83377

1

96998

10

98259

13

99579

13

98259

D3535-37

Wearshoe

Manufactured No

110 Each 8.0000

1 79 SP

Location

Loc Qty

Loc Code

FP001

8

84827

8

84827

D3536-37

Gasket

Manufactured No

110 Each 11.0000

1 13-07-03 SP

Location

Loc Qty

Loc Code

FP001

11

66823

2

82623

5

86250

4

86250

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4.6 206L/L-1/L-3/L-4 HIGH GEAR SKIDTUBES

ITEM	QTY -411	QTY -412	QTY -413	QTY -414	QTY -441	QTY -447	QTY -448	QTY -451	QTY -513	PART NUMBER	DESCRIPTION
	X									D206-642-411	SKIDTUBE INSTALLATION, LH
		X								D206-642-412	SKIDTUBE INSTALLATION, RH
			X							D206-642-413	SKIDTUBE INSTALLATION, LH
				X						D206-642-414	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-441	SKIDTUBE
						X				D206-642-447	WEARSHOE KIT (REPLACES -443)
							X			D206-642-449	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-481	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2850-7	SKIDTUBE ASSEMBLY
1									1	D4361-043	SKIDTUBE ASSEMBLY
2A					22				10	D2851-1	* PLUG ⁽¹⁾
2B					22				10	D2851-3	* O-RING ⁽¹⁾
3					1				1	D2846	* AFT CAP ⁽¹⁾
4					2				2	MS27039-1-08	* SCREW ⁽¹⁾
5					2				2	NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN860JD10L)
6	1		1							D2832-1	SADDLE, FWD OUT, LH
6		1		1						D2832-2	SADDLE, FWD OUT, RH
7	1		1							D2833-1	SADDLE, FWD IN, LH
7		1		1						D2833-2	SADDLE, FWD IN, RH
8	1		1							D2836-1	SADDLE, AFT OUT, LH
8		1		1						D2836-2	SADDLE, AFT OUT, RH
9	1		1							D2839-1	SADDLE, AFT IN, LH
9		1		1						D2839-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2852	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN860JD10)
13	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN880JD518)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN880JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-15	WEARSHOE (REPLACES D2656-16)
22B					1	1				D3536-15	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-37	WEARSHOE (REPLACES D2656-37)
24B					1	1				D3536-37	GASKET
26A					60	60				MS27039C1-08	SCREW
26B					60	60				NAS1149D0332J	WASHER (OR AN860JD10L)
26C					60	60				ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2868-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN405A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN860C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2855)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2834	SADDLE SPACER
39	2	2	2	2						D2835	SADDLE SPACER
40									2	D3414-041	LUG ASSEMBLY (REPLACES D2859)
41									4	AN3C37A	BOLT
42									8	D2852	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN860C10)

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Revision: P
Date: 13.02.12

DART AEROSPACE USA, INC.

IIN-D206-642
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ITEM	QTY -411	QTY -412	QTY -413	QTY -414	QTY -441	QTY -447	QTY -449	QTY -451	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4368-041	FWD WEARPLATE ASSY
51							1	1		D4368-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							3			D2848	SPACER
54A							10	10		AN3-38A	BOLT
54B							10	10		NAS1148C0332R	WASHER (OR AN880C10L)
54C							10	10		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2850-7 OR D4361-043 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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